



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3724-042
Job Sheet 177756



Part No: D3724-042

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/17/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A new issue 08-02-07 DD verified by: ec IPP Rev: B ecn 1154p 08-03-13 DD verified by: ec IPP Rev: C ecn 1158 08-03-19 DD verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/31/18	5/31/18	0.00	0.00	Start Up Large Fab-4		11-18-5-28
100	Large Fab	1 pcs	5/31/18	5/31/18	0.00	5.95	Large Fab 8		11-18-5-28
110	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC6		CPL
120	Large Fab	1 pcs	5/31/18	5/31/18	0.00	5.95	Large Fab 2		11-18-5-28
130	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC9		CPL
135	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC5		CPL
140	HandFinish	1 pcs	5/31/18	5/31/18	0.00	0.49	HandFinish1		SA 18-05-28
150	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC3		CPL
160	Large Fab	1 pcs	5/31/18	5/31/18	0.00	5.95	Large Fab 2		11-18-06-08
170	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC10		11-18-06-08
180	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC5		11-18-06-08
190	HandFinish	1 pcs	5/31/18	5/31/18	0.00	0.49	HandFinish1		SA 18-06-11
200	Powdercoat	1 pcs	5/31/18	5/31/18	0.00	0.34	Powdercoat1		11-18-06-13
210	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC3		11-18-06-13
220	HandFinish	1 pcs	5/31/18	5/31/18	0.00	0.49	HandFinish3		11-18-06-13
230	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC5		11-18-06-13
240	Packaging	1 pcs	5/31/18	5/31/18	0.00	0.00	Packaging3-1		11-18-06-13
250	QC21-SA	1 Ea	5/31/18	5/31/18	0.00	0.00	QC21		11-18-06-13

Part Op 100 - 1-Cut D3737-2 as per dwg D3737 2-Cut D3738-2 as per dwg D3738 3-Deburr and bevel ends for welding
Descriptions: 120 - 1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724 2-Grind flush
160 - *****REMEMBER PAT DIMENSION ARE WITH THE END CAPS***** 1-Apply Magnabond before installing rivets
A/R Magnabond 6398 Batch: 138848 2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per
dwg D3724 (RIVET HEAD MUST FACE FWD OF STEP) 3-Transfer holes from D3730-1 and D3741-1 into step as per
dwg D3724 4-Deburr 5-Apply magnabond as per dwg D3724 A/R Magnabond 6398 Batch: 138848 6-Rivet
brackets in place on step as per dwg D3724 7-Weld both end cap as per Dwg D3724 8-Grind end cap welds flush Inspect
for foreign object per QSI 024
190 - 1- Touch up with alodine
200 - START TIME: 7:30 OVEN TEMPERATURE: 320° FINISH TIME: 8:00

Job BOM

Component Name	Quantity	Operation	Container
Step Extrusion	1 Ea (1 ea)	90-Start up Operation	50566116
Gusset	1 Ea (1 ea)	120-Large Fab	
Cherry Rivet	32 Ea (32 ea)	160-Large Fab	50566116

D2734	Step End Plate	2 Ea (2 ea)	160-Large Fab
D3728-1	Step Bracket	3 Ea (3 ea)	160-Large Fab
729-1	Step Bracket	1 Ea (1 ea)	160-Large Fab
736-1	Angle	8 Ea (8 ea)	160-Large Fab
741-1	Angle	8 Ea (8 ea)	160-Large Fab
MS20470AD5-11	Rivet	12 Ea (12 ea)	160-Large Fab
MS20470AD5-16	Rivet	4 Ea (4 ea)	160-Large Fab

5068695
 5055913
 5055917
 5061690 2x 5076367 6x
 5076553 6x
 F107100-7
 F107100

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	146	0
120-Large Fab	D3733-1	1	9	0
160-Large Fab	CR3213-5-4	32	297	0
	D2734	2	40	0
	D3728-1	3	3	0
	D3729-1	1	1	0
	D3730-1	8	2	0
	D3741-1	8	2	0
	MS20470AD5-11	12	988	0
	MS20470AD5-16	4	683	0

Part Specifications

Specifications could not be found.

Plex 5/17/18 12:59 PM Dart.lajeunesse.marie

MD 18 Jun 2019

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

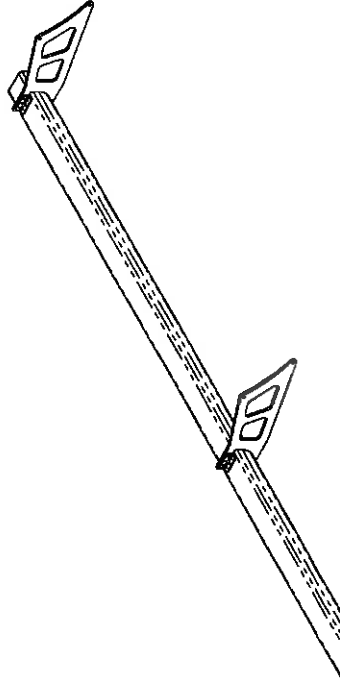


NCR No. 19-7165

Route update only

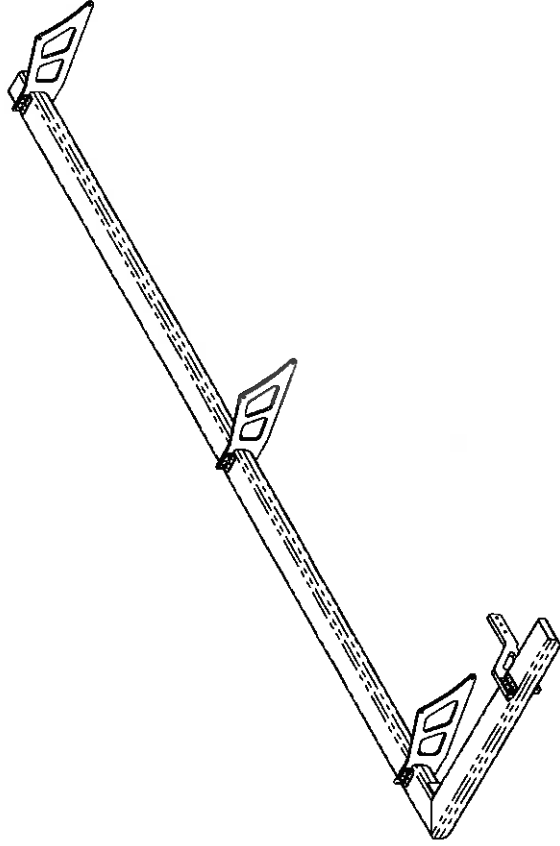
Job: 177777		DISPOSITION		DEPARTMENT/PROCESS					
Part No. D3724-042		Rework ☒ Scrap ☐ Use-as-is ☐		Supply Chain ☒ Cross tube ☐ Small Fab ☒ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☒ Rec/Store/Packaging ☒ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: 18/6/5	Sequence #: 160	QTY Affected: 1		MRB (QSI042) DAS 12 18/6/5 9-89					
Description Work Order Deviation		Disposition							
There is no Magnabond in stock		Acceptable to use Proseal instead of Magnabond. Proseal Magnabond is non-structural, proseal is used in other products for similar applications applications							
Completed By: SS-18/6/5		Lead hand / Supervisor D 13-07-05							
QC / QA Coordinator D 13-07-05									
Root Cause		FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☒ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: no stock				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☒ Misread ☐			

3			2		1		
QTY -041	QTY -042	PIN	DESCRIPTION				
X		D3724-041	STEP ASSEMBLY				
	X	D3724-042	STEP ASSEMBLY				
2	2	D2734-1	END PLATE				
8	8	D3730-1	ANGLE				
1	1	D3733-1	GUSSET				
1		D3737-1	STEP				
	1	D3737-2	STEP				
1		D3738-1	STEP				
	1	D3738-2	STEP				
1	1	D3747-1	DECAL				
32	32	CR3216-5-4	RIVET				
12	12	MS20470AD5-11	RIVET				
4	4	MS20470AD5-16	RIVET				
8	8	D3741-1	ANGLE				
3	3	D3728-1	STEP BRACKET				
1	1	D3729-1	STEP BRACKET				



D

C



D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE) /B

180017700

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 13.89 lbs
 - 8) WELDING: PER DART QSI 004
 - 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
 - 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L. SHEET 2) TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3738-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. 3) REVISED D3741-1 C & SECTION E/E. 90.118 WAS 90.008. ZONE 1 & 2 DIM WAS 50.22. 2.60 DIM WAS 2.66. ADD SECTION G-G.		AJS	08.02.26
	A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	W	DRAWING NO.		
MFG. APPR.	W	D3724		
APPROVED	W	TITLE		
DE APPR.	W	STEP ASSY		
DATE	08.02.26	SHEET 1 OF 2		
		SCALE		
		NTS		
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